

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2015-135 Date Opened: 30-Dec-15 Title: AssemblyAircraft OEM: Bell Aircraft Model: 206L Product Type: Cargo Basket Product Model: Standard Quantity: 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JR
N/A
JR
JR
N/A
JR
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JR
JR

Drawing List

Drawing #	Rev #	Description	Initial or N/A
69810	3	Basket	JR
69811	3	Body	JR
69812	4	Lid	JR
69822	1	Aft Hoop	JR
69827	2	Placard	JR

Traveller

Install walkway on lid
Install lid on basket body
Re-tap mounting lug holes and install mount lugs
Install handle brackets
Install handle
Install lid prop
Install data plate

Initial or N/A

JR
JR
JR
JR
JR
JR
JR

Work performed by:

Print: Jason RekveSign: Jason RekveSCA: AD01Date: 30-Dec-15

ICC / Dual Inspection performed by:

Print: Jeff ClarkeSign: Jeff ClarkeSCA: AD01Date: 30-Dec-15

Work Order closed by:

Print: Jason RekveSign: Jason RekveSCA: AD01Date: 30-Dec-15

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JR
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

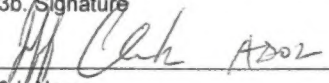
N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JR
N/A
N/A

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2015-135	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	Cargo Basket	69810-01	1	69801-83	New	
12. Remarks Modified with Lid Step and Front End Cutout IAW DCL704						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
<input type="checkbox"/> Non approved design data specified in block 12.						
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 30 Dec 2015		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

HMC Helicopters



WO# 2015-135

Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2015-135

Date Open: 30 Dec 15

dk

1. Lid Assembly

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant.
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket.
 - ii. Drill #30 through placard and bracket, using holes in placard.
 - iii. Remove placard and de-burr holes in placard and on bracket.
 - iv. Locate placard on bracket, and cleco in place.
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
 - ii. Pull tread plate from stock. Shear tread plate to length.
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
 - v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
 - vii. De-burr holes in lid tubes.
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
 - ix. Set tread plate in place, secure with clecos if necessary.
 - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

dk

2. Body Assembly

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
 - ii. Run 3/8-24 tap into attachment lugs to clear threads.
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
 - v. Torque to ??

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90"
 - 5. 940, 946, 959 – 95"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

- d. Record PO of hinge and rivets on attached material tracking list.

OK

4. Install Handle

a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.

OK

5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

jc.

6. Final Inspection

Dual inspection by a different person than assembled the basket.

a. Check for general condition and correct assembly:

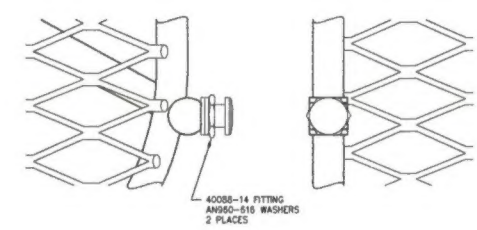
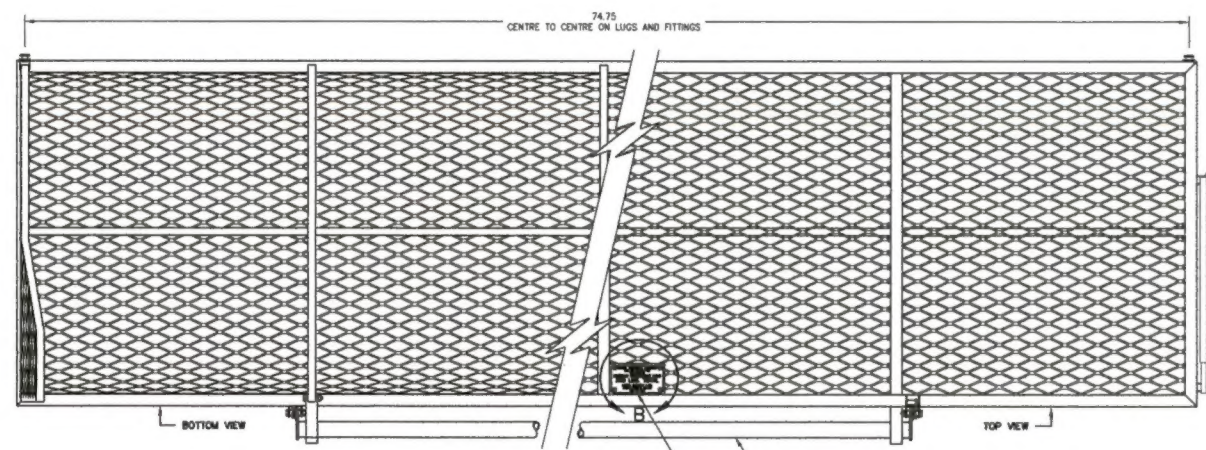
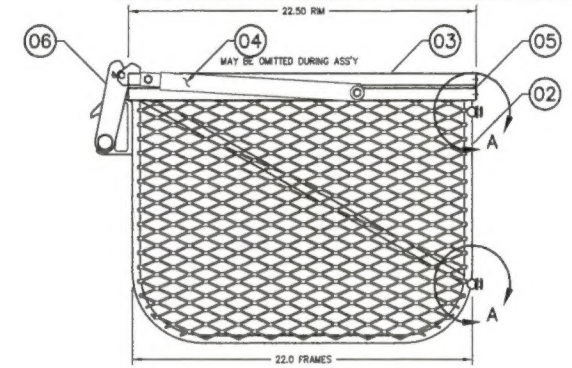
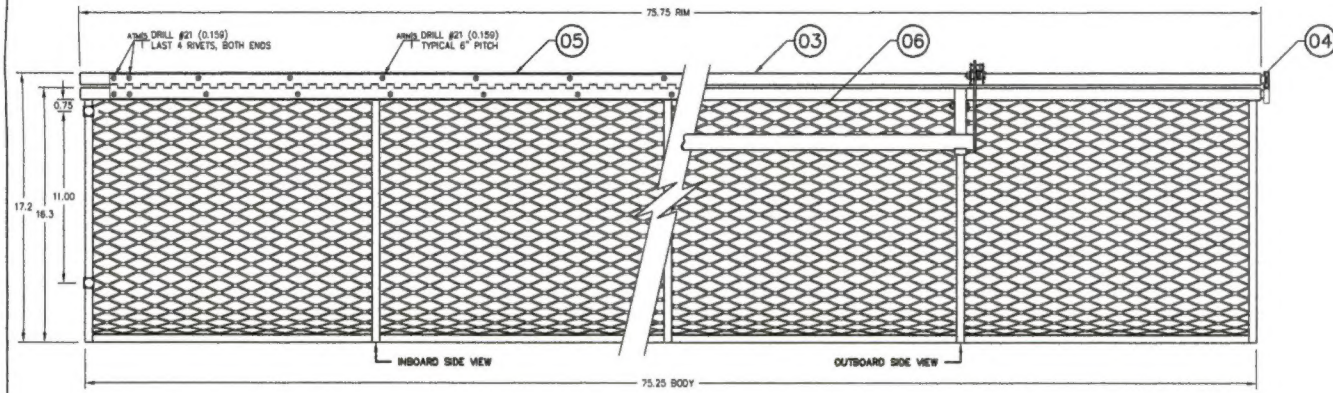
- i. Bolts are tight
- ii. Rivets are installed correctly
- iii. Handle operates correctly
- iv. Lid brace operates correctly

b. Check that PO/WO numbers have been recorded.

2015-135

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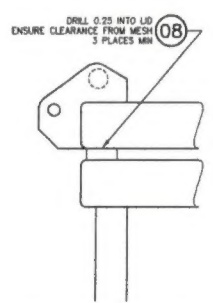
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	CHANGED LUGS	BJC	08/11/2006
2	PLACARD CHANGED, AFT END MODIFIED FOR CROSS TUBE CLEARANCE	BJC	29/06/2007
3	HINGE RIVETS CHANGED, HANDLE DETAILS CHANGED, PLACARD CHANGED	BJC	14/10/2011



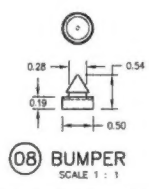
DETAIL A

SCALE 1 : 1
LOOKING AT LOWER ATTACHMENT, UPPER ATTACHMENT SIMILAR
TYPICAL FRONT AND REAR

NOTE:
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS
AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

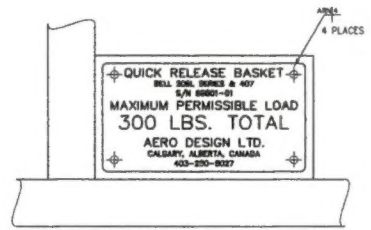


BUMPER INSTALLATION
SCALE 1 : 1



08 BUMPER
SCALE 1 : 1

01 CARGO BASKET ASSEMBLY



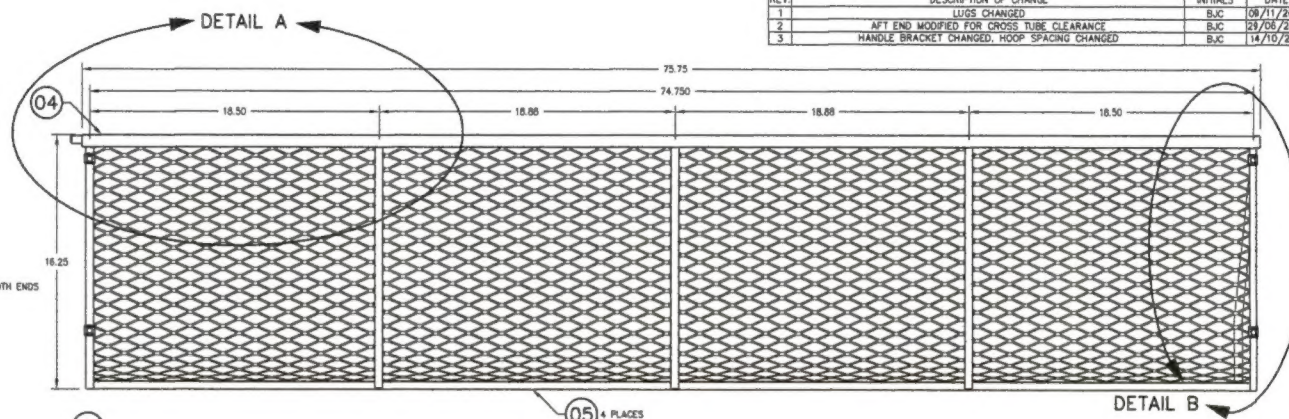
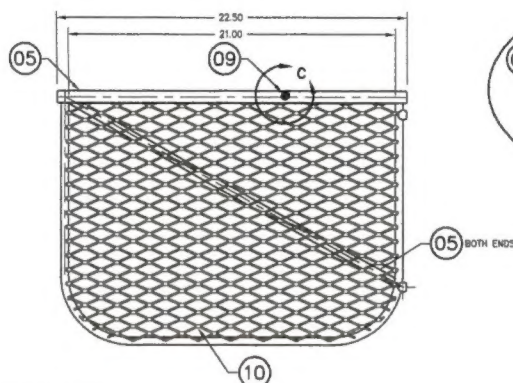
DETAIL B

SCALE 1 : 1
LOOKING AT PLACARD BRACKET

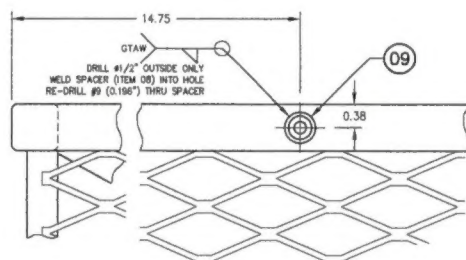
A/R	AN660-616	WASHER			
4	4008B-14	FITTING	ANCR4		
4	CR3213-4-02	CHERRY RIVET			
8	CR3523-5-02	CHERRY RIVET			
A/R	CR3213-5-02	CHERRY RIVET			
3	49205-14	BUMPER	ARGUS INDUSTRIES		
1	69827-01	07 PLACARD			
1	64235-01	08 HANDLE BAR INSTALLATION			
1	MS20001P4	05 PLANO HINGE			6 FEET LONG
1	36280-01	04 BRACE ASSEMBLY			
1	69812-01	03 LID ASSEMBLY			
1	69811-01	02 BASKET BODY ASSEMBLY			
1	69810-01	01 CARGO BASKET ASSEMBLY			
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	STOCK SIZE

BASIC CODE		DASH NO. FOR DIAMETER		APPROVALS		DATE	
REF. NAS 523		R=MFD. HEAD NEAR SIDE		DRAWN: JEFF CLARKE		11 APR 2006	
		F=MFD. HEAD FAR SIDE		CHECKED: E. BURGOIN			
		DASH NO. FOR LENGTH		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			
				DECIMALS ANGLES			
				X.XXX ±0.010 ±1/2"			
				X.XX ±0.03			
				X.X ±0.1			
BASIC CODES:				AERO DESIGN LTD.			
BJ=MS20470AD				CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M			
BB=MS20426AD				2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7			
AR=CR3213				Tel: (403) 250-8007 Fax: (403) 250-8303 aerodesign@shawplanet.net			
ATN=CR3523				BELL 206L 407			
				QUICK RELEASE CARGO BASKET			
				CARGO BASKET ASSEMBLY			
				SCALE 1 : 4			
				SHEET 1 OF 1			
				A1 69810 3			

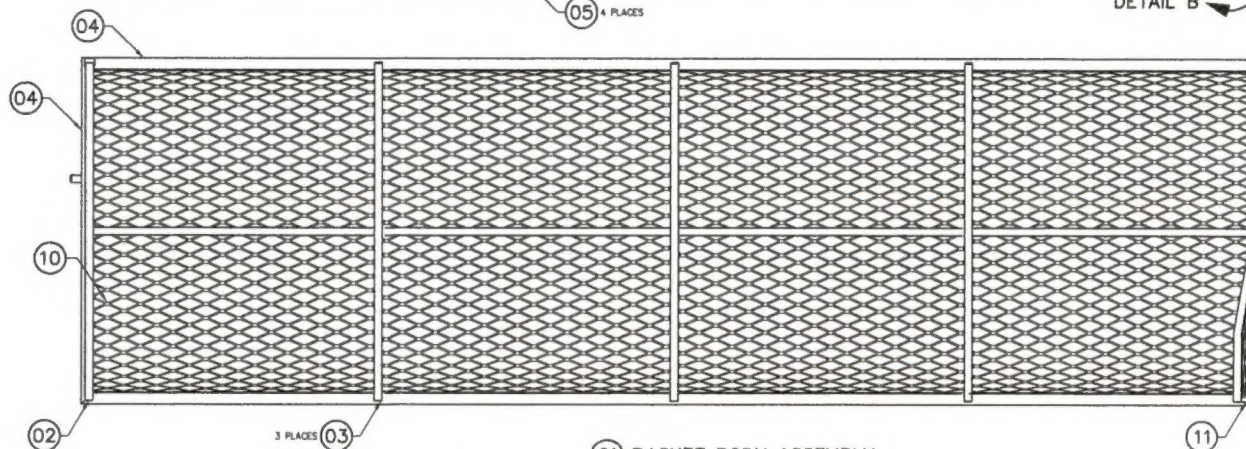
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	LUGS CHANGED	BJC	08/11/2006
2	AFT END MODIFIED FOR CROSS TUBE CLEARANCE	BJC	29/06/2007
3	HANDLE BRACKET CHANGED, HOOP SPACING CHANGED	BJC	14/10/2011



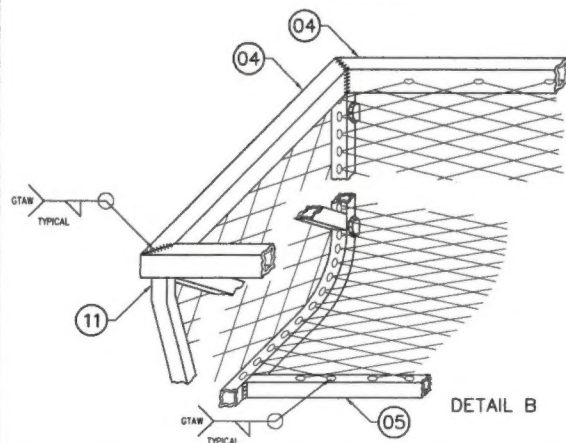
- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
 2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
 3. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
 4. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.



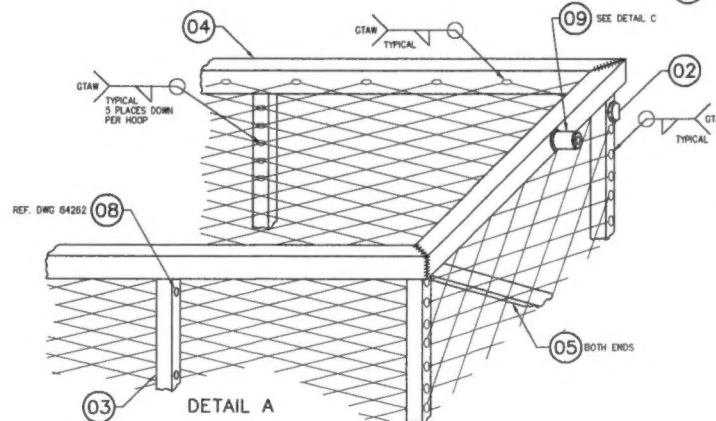
DETAIL C
SCALE 1:1
VIEW LOOKING AT FRONT RIM OF BASKET



01 BASKET BODY ASSEMBLY



DETAIL B



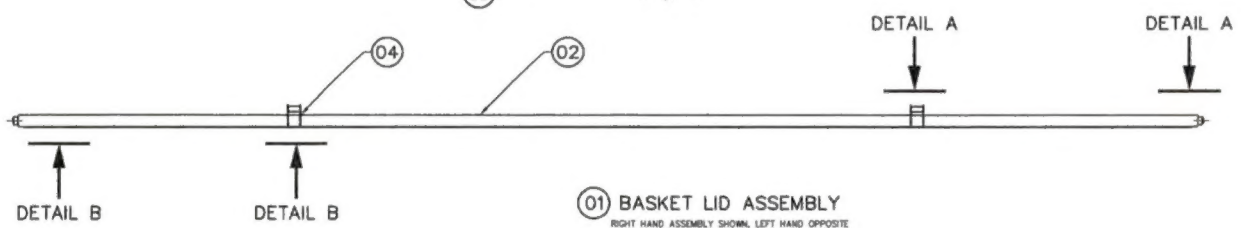
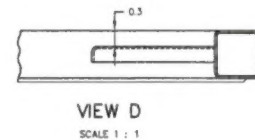
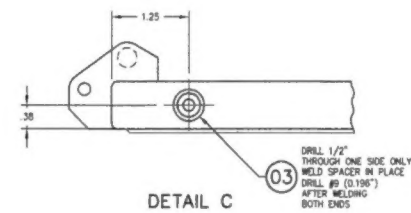
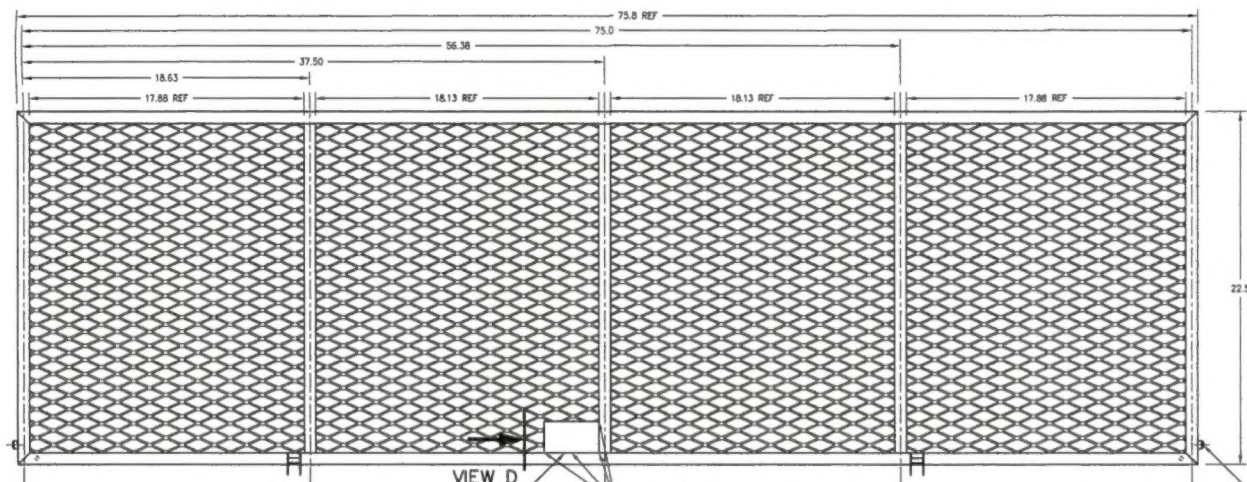
DETAIL A

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	59822-01	11	AFT END HOOP	STEEL	COMMERCIAL	
A/R	3/4-16F	10	MESH			
1	49215-01	09	SPACER			
1	84262-01	08	HANDLE BRACKET ASSEMBLY			
	--	07	--			
	--	06	--			
A/R	--	05	TUBE	4130 STEEL, COND. N	MIL-T-6736	0.5 X 0.035 SQR. TUBE
A/R	--	04	TUBE	4130 STEEL, COND. N	MIL-T-6736	0.75 X 0.035 SQR. TUBE
3	49210-02	03	HOOP			
1	59821-01	02	FORWARD END HOOP			
1	69811-01	01	BASKET BODY ASSEMBLY			

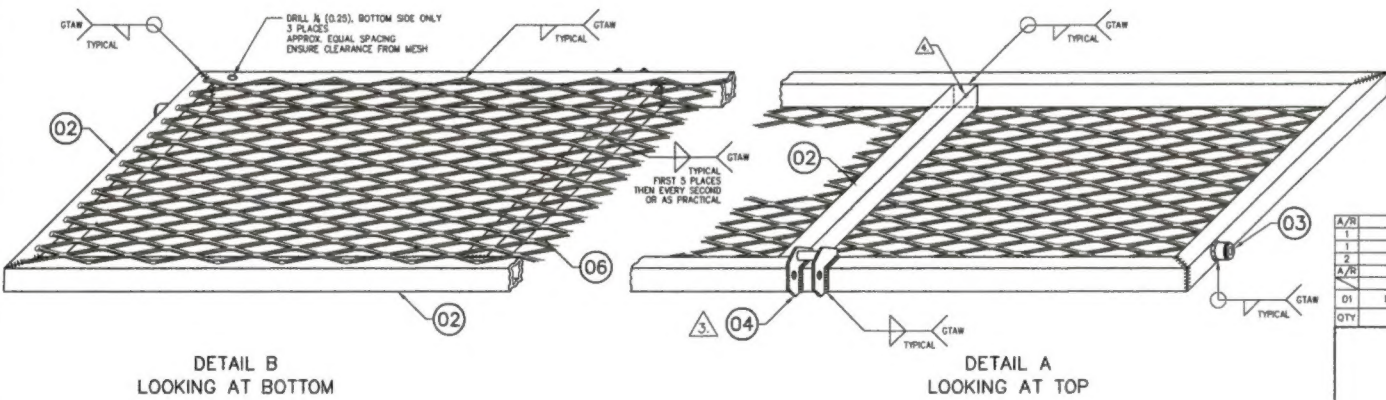
APPROVALS		DATE	
DRAWN:	JEFF CLARKE	11 APR 2006	
CHECKED:	E. BURGOIN		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			
DECIMALS		ANGLES	
X.XXX	±0.010	±1/2°	
X.XX	±0.03		
X.X	±0.1		

AERO DESIGN LTD.			
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 280M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8087 fax: (403) 250-8383 aerodesign@shawcanet.net			
BELL 206L, 407 QUICK RELEASE CARGO BASKET BASKET BODY ASSEMBLY			
SCALE 1:1	DWG. NO.	REV.	
SHEET 1 OF 4	A1	69811	3

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL RELEASE		
1	CHANGED LOCATIONS OF SUPPORTS	RR	20 FEB 08
2	CHANGED HANDLE BRACKET, ADD LEFT HAND CONFIGURATION	BJC	28 JAN 10
3	CHANGED LOCATION OF SUPPORTS, REMOVE SIDED CONFIGURATIONS	BJC	15 SEPT 11
4	TITLE BLOCK UPDATED; B4262 CHANGED TO B4283; WELDING ROD UPDATED; # OF WELDS DOWN BRACE TUBES INCREASED; REFERENCE DIMENSIONS ADDED	BJC	11/07/2014
	1/4" HOLES FOR BUMPERS ADDED, VIEW D ADDED		



01 BASKET LID ASSEMBLY
RIGHT HAND ASSEMBLY SHOWN, LEFT HAND OPPOSITE



DETAIL B
LOOKING AT BOTTOM

DETAIL A
LOOKING AT TOP

- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
 2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C. 4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT. STAINLESS AND 4130 STEEL: WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
 3. INSTALL ITEM 4 (LID HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING B4263.
 4. DRILL #30 (0.125) HOLES IN LONG TUBE MEMBERS AT BRACE LOCATIONS TO VENT WELD GASSES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
 5. FINISH: THOROUGHLY CLEAN AND POWDER COAT LID ASSEMBLY.

A/R	3/4-16F	06	MESH	MILD STEEL	COMMERCIAL	
1	36204-10	05	PLACARD BRACKET			
1	B4263-01	04	LID HANDLE PROVISIONS ASSEMBLY			
2	49218-01	03	SPACER			
A/R	69812-01	01	BASKET LID ASSEMBLY	4130 STEEL, COND. N	MIL-T-6736	0.75 X 0.035 SQ. TUBE
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
			LIST OF MATERIALS			
			APPROVALS			
			DATE			
			DRAWN: JEFF CLARKE 11 APR 2008			
			CHECKED: E. BURGON			
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			
			DECIMALS ANGLES			
			X.XXX ±0.010 ±1/2°			
			X.XX ±0.03			
			X.X ±0.1			
			AERO DESIGN LTD.			
			9088A MALASPINA ROAD			
			POWELL RIVER, BC, CANADA, V8A 0G3			
			TEL: 804 480.3876 www.aerodesign.ca			
			QUICK RELEASE CARGO BASKET BASKET LID ASSEMBLY			
			SCALE 1 : 4			
			SHEET 1 OF 1			
			A1 69812 4			

NOTICE

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	CHANGED TO ENGRAVED ALUMINUM	BJC	19 JUNE 2007
2	INCREASED LOAD	BJC	26 OCT 2011

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
 "QUICK RELEASE BASKET" - 0.125 HIGH
 "BELL 206L SERIES & 407" - 0.080 HIGH
 "S/N 69801-XX" - 0.080 HIGH
 "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
 "300 LBS. TOTAL" - 0.200 HIGH
 "AERO DESIGN LTD." - 0.125 HIGH
 "CALGARY, ALBERTA, CANADA" - 0.080 HIGH
 "403-250-8027" - 0.080 HIGH

DRILL #30 (0.129)
4 PLACES



01 PLACARD

1	69827-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
			APPROVALS	DATE	AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net	
			DRAWN: JEFF CLARKE	24 APR 2006		
			CHECKED: E. BURGAIN			
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		BELL 206L SERIES AND 407 QUICK RELEASE CARGO BASKET PLACARD	
			SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
			SHEET 1 OF 1	A4	69827	2